

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023436**Date Inspected:** 30-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai

|                                    |                                    |           |            |                                  |            |                      |
|------------------------------------|------------------------------------|-----------|------------|----------------------------------|------------|----------------------|
| <b>CWI Name:</b>                   | Tian Lei, Liu Fa Wen, Chen Shigang |           |            | <b>CWI Present:</b>              | <b>Yes</b> | <b>No</b>            |
| <b>Inspected CWI report:</b>       | <b>Yes</b>                         | <b>No</b> | <b>N/A</b> | <b>Rod Oven in Use:</b>          | <b>Yes</b> | <b>No</b> <b>N/A</b> |
| <b>Electrode to specification:</b> | <b>Yes</b>                         | <b>No</b> | <b>N/A</b> | <b>Weld Procedures Followed:</b> | <b>Yes</b> | <b>No</b> <b>N/A</b> |
| <b>Qualified Welders:</b>          | <b>Yes</b>                         | <b>No</b> | <b>N/A</b> | <b>Verified Joint Fit-up:</b>    | <b>Yes</b> | <b>No</b> <b>N/A</b> |
| <b>Approved Drawings:</b>          | <b>Yes</b>                         | <b>No</b> | <b>N/A</b> | <b>Approved WPS:</b>             | <b>Yes</b> | <b>No</b> <b>N/A</b> |
|                                    |                                    |           |            | <b>Delayed / Cancelled:</b>      | <b>Yes</b> | <b>No</b> <b>N/A</b> |
| <b>Bridge No:</b>                  | 34-0006                            |           |            | <b>Component:</b>                | OBG        |                      |

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

This inspector observed ZPMC personnel welding of components identified as Lift 13 & 14 lifting frame beam.

Bay Number 5

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 3025TR1-002 for weld(s) 001~016. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10291.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 3025TR1-001 for weld(s) 001~016. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10291.

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ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 3026TR1-001 for weld(s) 001~016. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10291.

### Bay Number 7

FCAW welding of complete joint penetration root pass welds located on Cantilever Box Bracket Assembly component identified as BK3004-001 weld no.(s) 003 & 004 Welder is identified as welder no. 046706. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

SAW welding of complete joint penetration welds located on Cantilever Box Bracket Assembly component identified as BK3004-001 weld no.(s) 003 & 004. Welder is identified as welder no. 216687. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2221-U4a-S-2.

### Bay Number 8

This inspector did not observe any work being performed in this bay today.

### Bay Number 9

FCAW welding of complete joint penetration welds located on Traveler Rail component identified as 3003TR2-001 weld no.(s) 026. Welder is identified as welder no. 059421. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration welds located on Traveler Rail component identified as 3003TR2-001 weld no.(s) 025. Welder is identified as welder no. 203805. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

Pertinent conversations are included in the body of the report.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Hernandez,Rene |
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| Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Hall,Steven |
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| QA Reviewer |
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